



- NOTES:
1. THIS IS A UHV ASSEMBLY. KEEP THE UHV PARTS CLEAN DURING ASSEMBLY AND WRAP UP FOR PACKING WITH ALUMINUM FOIL.
 2. DEVICE SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 x 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:
ALCATEL ASM-110TCL
VARIAN NCR 925 OR 936
VEECO MS-9, MS-90 OR MS-18
DuPONT CEC 24-120B
CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.
FINAL TEST WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.
 3. BEFORE ASSEMBLY OF SWAGELOK MALE CONNECTORS, USE SILVER COOP THREAD LUBRICANT (FROM SWAGELOK CO.) TO ALLOW CONNECTION TO BE DISASSEMBLED WITHOUT SPECIAL TOOLS.
 4. ALL DIMENSIONS WITH [] ARE MILLIMETERS.
 5. WATER PRESSURE TEST AT 500 PSI AFTER ASSEMBLING.

- INSTRUCTIONS FOR INSTALLATION OF TUBING
1. INSTALL THE TUBE INTO THE FITTING UNTIL IT IS BOTTOM AGAINST THE SHOULDER OF THE BODY.
 2. THE NUT OF SWAGELOK TUBE FITTING SHALL BE TIGHTEN 1-1/4 TURN FOR FULL PULL-UP. THE SWAGELOK GAP GAP INSPECTION GAGE SHALL BE USED TO CHECK FOR SUFFICIENT PULL-UP.

SOURCE

(SWAGELOK)
DEARBORN VALVE & FITTING CO.
1540 N. OLD RAND ROAD
P.O. BOX 847
WAUCONDA, IL 60084-0847
708-526-6900
FAX: 708-526-1221

3	SS-600-1-4	CONNECTOR MALE TUBE FITTING	SST	4
2	P41020109-210000	4" I.D. BE WINDOW WELDMENT ASSEMBLY		1
1	P41020109-200001	4" I.D. BE WINDOW TUBING	SST	2
ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES: X - .001 XX - .002 XXX - .005 SURFACE ROUGHNESS: 125 REMOVE ALL BURRS AND BREAK SHARP EDGES (RANA) SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AMS 491 DIMENSIONS & TOLERANCES IN ACCORDANCE WITH LATEST AMS Y14.5				
LOG NUMBER A13478		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
DRAWN BY MUSCIA		DATE 9/27/93	CHECKED BY DATE	TITLE ADVANCED PHOTON SOURCE I.D. FRONT END 4" I.D. BE WINDOW ASSEMBLY
DESIGNED BY MUSCIA		PROJECT MGR.	APPROVED/RELEASED	
RESPONSIBLE ENGINEER				
MATERIAL SEE PARTS LIST		SCALE 1:1	SHEET 1 of 1	DWG. NUMBER P41020109-200000-00